

Work Order ID 72422

Monday, July 25, 2011 1:22:08 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-07-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580-041

Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

1 6 8/21/08/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for welding as per QSI 004

x1

od

u/08/03

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

DP

11-8-4

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004

A/R Aluminum Rod

M15778

BE 11/08/05

2-Grind welds on step as per Dwg D2580

3-Weld spacers as per dwg D2580

BE 11/08/05

A/R M15778

3- *** N/A**** Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

GRIND FLUSH BE 11/08/08

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

} DE 11/08/08

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 11/08/08

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Sulosko

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sulosko

Quality Control

P10 →
n/a
J

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

IX Ø M-6/10/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: Fault Category: Landing Gear NCR: Yes No DQA: Date:
 Resolution: Re work Disposition: Re work QA: N/C Closed: Date:

NCR: <u>72422</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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<u>W08/10</u>	<u>#140.1</u>	<u>Found at inspection that the 2nd hole from AFT (Saddle hole) is not fitting test SADDLE.</u>	<u>CP</u> <u>11.08.10</u> <u>BT/HR</u>	<u>- Drill out + Remove D2579 and Replace B</u>			<u>CP</u> <u>11.08.10</u> <u>BT/HR</u>	<u>W08/10</u>
		<u>R.C. hole pull/cross butt space pulled when welding only 1 side affected. Process</u>	<u>CP</u> <u>11.08.10</u> <u>BT/HR</u>	<u>- Re weld as per Q2700y A/R</u> <u>- Re counter bore and Deburr.</u>			<u>CP</u> <u>11.08.10</u>	<u>W08/10</u>
		<u>(Tooling, w/o, Drawings are all good all Employees completely trained)</u>	<u>CP</u> <u>11.08.10</u>	<u>W/O</u> <u>W08/10</u> <u>Sub/10</u>			<u>CP</u> <u>11.08.10</u>	

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Reference:

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
320
9:30

0.00

1X Ø m-11/08/18

190

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

1 Ø M 11/08/18

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Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M117516

Sikaflex expire date: 12/05

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M117516

Sikaflex expire date: 12/05

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M118213

1 0 11/08/2011

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/16/23

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

0

220



Packaging

Packaging

Packaging

0.00

PP 72286

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

11/8/23

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/8/23
ME
11-08-23

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 72422

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 7/25/2011

Required Date: 8/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
 KJ IPP Rev P 10.02.19
 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
 10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4202-1 	D2579	Manufactured	No			140	Each	443.0000	20	20			
Spacer													

Location	Loc Qty	Loc Code
LG002	443	
66929	106	
67129	196	
67308	1	
67430	140	

BE 11/08/05
 B 72199 x20

D2580-1 		Manufactured	No			110	Each	4.0000	1	1			
205 Skidtube bent detail													

Location	Loc Qty	Loc Code
LG	4	
71014	2	
71784	2	

BE 11/08/03
 B 72461 x1

D2576-3 		Manufactured	No			140	Each	42.0000	1	1			
Step (maching detail)													

Location	Loc Qty	Loc Code
LG	42	
66156	42	

BE 11/08/05

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 72422

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/25/2011

Required Date: 8/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

37.0000

1

1



Cap



11

11/08/22

Location

Loc Qty

Loc Code

FP007

37

53791

2

65519

2

65569

33

X1

AN3-5A

Purchased

No

200

Each

1,048.000

2

2



Bolt



11

11/08/22

Location

Loc Qty

Loc Code

ST350

1048

115371

275

117423

773

X2

AN960JD10L

NAS1149D0332J

Purchased

No

200

Each

0.0000

2

2



Washer

1117087



(X2) 11

11/08/22

ALS7-1032-130

Purchased

No

200

Each

1,861.000

50

50



Insert



11

11/08/22

Location

Loc Qty

Loc Code

ST282

1861

117717

899

118386

962

1118237

X50

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 7/25/2011

Required Date: 8/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

200

Each

1,333.000

50

50



50 11/08/22

BOLT

Location

Loc Qty

Loc Code

ST350

1333

117313

2

1118628

50

117688

269

117795

500

117872

22

118012

500

118112

40

AN960C10L

NAS1149C0332

Purchased

No

200

Each

0.0000

50

50



1118306



(x50) 11/08/22

washer

D3566-13

Manufactured

No

200

Each

35.0000

1

1



11/08/22

Gasket

Location

Loc Qty

Loc Code

FP

16

69281

16

51

FP014

19

68341

1

72149

18

D3566-5

Manufactured

No

200

Each

18.0000

1

1



11/08/22

Gasket

Location

Loc Qty

Loc Code

FP015

18

68961

6

71601

12

51

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Start Date: 7/25/2011

Required Date: 8/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 200 Each 24.0000 2 2



Gasket



Handwritten: 11/08/22

Location Loc Qty Loc Code

FP011 22
70769 10
71580 12
FP015 2
68924 2

Handwritten: B72848

Handwritten: 12

D3564-11 Manufactured No 200 Each 12.0000 1 1



Wearshoe



Handwritten: 11/08/22

Location Loc Qty Loc Code

FP019 12
67591 12

Handwritten: 12

Handwritten: 1

D3564-13 Manufactured No 200 Each 20.0000 1 1



Wearshoe



Handwritten: 11/08/22

Location Loc Qty Loc Code

FP016 9
69280 9
FP017 11
71594 11

Handwritten: 1

D3564-9 Manufactured No 200 Each 14.0000 1 1



Wearshoe



Handwritten: 11/08/22

Location Loc Qty Loc Code

FP019 14
67590 4
69943 10

Handwritten: B72208

Handwritten: 1

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Start Date: 7/25/2011

Required Date: 8/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No

200

Each

16.0000

1

1



Wearshoe



u/08/22

Location

Loc Qty

Loc Code

FG

2

34806

2

1372164

✓

FP019

14

70864

14

D2594-3

Manufactured No

200

Each

740.0000

16

16



O-Ring, 205 Skidtube



u/08/22

Location

Loc Qty

Loc Code

FP-A

740

65518

54

66952

686

x16

D2594-1

Manufactured No

200

Each

201.0000

16

16



Plug, 205 Skidtube



u/08/22

Location

Loc Qty

Loc Code

FP-A

201

42807

28

67441

7

68943

166

x16

W/O:		WORK ORDER CHANGES					
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DART

DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 #**DEO ATTACHED**
UNDER REVIEWPH 11.06.30
RMV PH 11.06.30

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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SUBJECT TO AMENDMENTWITHOUT NOTICE
WORK ORDER

72422

H/110720

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH

RELEASED
07-06-28

~~DEO ATTACHED~~

Technical drawing of a circular component with a central hole and a rectangular slot. The drawing includes the following labels and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX-241/-29
- AN3-5A BOLT (1)
- AN96JDI10L WASHER (1) (2 PLACES)
- D2855 CAP
- 0.40

A technical diagram of a circular web assembly. The diagram shows a circle representing the web with several internal features labeled:

- D2579 SPACER**: Points to a horizontal bar across the center.
- D2596 WEB (REF)**: Points to the outer circular boundary.
- ALST-1032-130 (REF) (TYP 50 PLACES)**: Points to small circular features near the bottom edge.

To the right of the diagram, there are instructions and a list of steps:

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

D2580-1 DRILLING DETAIL

37.50
DISTANCE TO AFT END
OF D2586 WEB

1.750

1.750

8.750

17.375

26.000

34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

91.500

190.0
(D2500-1)

38.0

REFER TO DETAIL A

REFER TO DETAIL A

CP 11.86

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

D

P P P P P P P P

B

1.5

1.5

1.5

REFER TO DETAIL C

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13



AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN	DRAWN BY
--------	----------

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DATE	07.02.27

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APPROVED	HA

DRAWING NO.	REV. D
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CP 11.06.30
RMV CP 11.06.30

D2580-1 DRILLING DETAIL

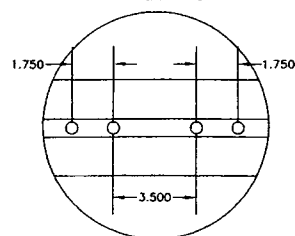


Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

RELEASED
07-06-2015

~~DEO ATTACHED~~

Technical drawing of a circular component with the following annotations and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to two small circular features on the top surface.
- SEAL WITH SIKAFLEX-241/-291**: Points to a rectangular area on the top surface.
- AN3-SA BOLT (1)**: Points to a bolt on the side of the component.
- AN960J10L WASHER (1) (2 PLACES)**: Points to two washer locations on the side.
- D2855 CAP**: Points to a cap on the side.
- SEE NOTE ii)**: Points to a specific feature on the side.
- 0.40**: Dimension indicating a length or radius.

Diagram of a circular web assembly with the following labels:

- D2579 SPACER
- D2596 WEB (REF)
- AL57-1032-130 (REF) (TYP 50 PLACES)

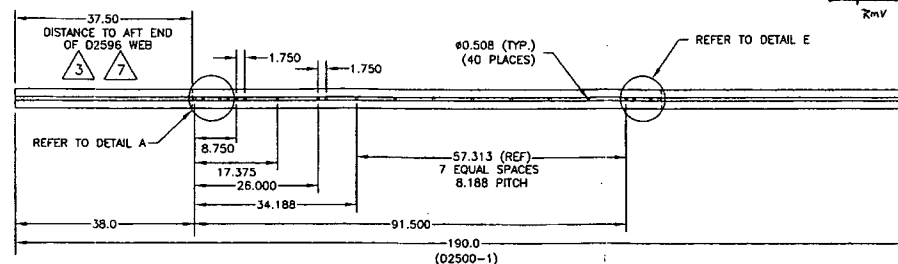
5

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

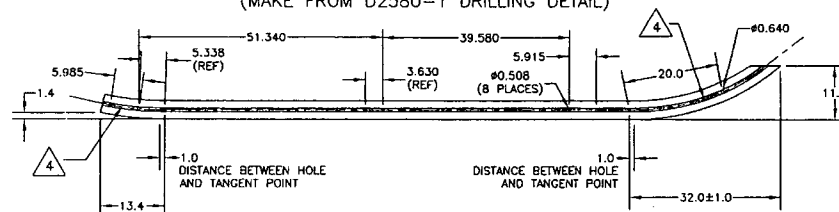
1. CHAMFER HOLE 0.050 x 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 x 1.00 DEEP

D2580-045 NOTES

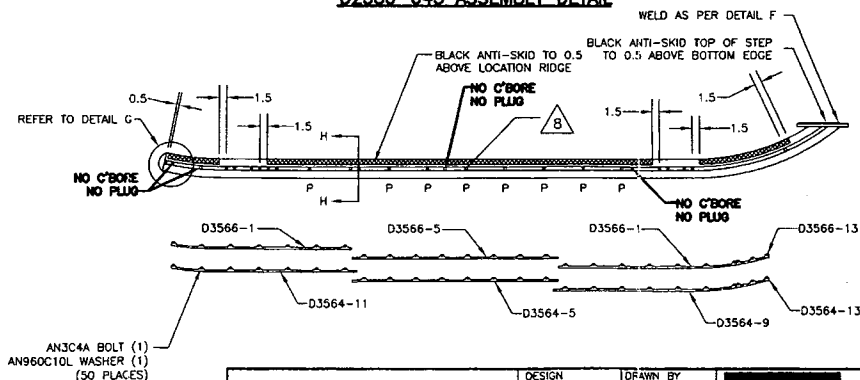
- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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HANESSBURY, ONTARIO, CANADA

CHECKED

APPROVED.

DRAWING NO.

REV. 0

DATE _____

TITLE
205 SKIDTUBE ASSEMBLY

SCALE

SCALE

07.02.27

1:24

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 258

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B69986
Part number: D205-634-041
Description: 205
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Art Evers Date of Test Coupon 11.06.24
Welder Barclay Elliot Date of Test Coupon 11/06/24

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

W/O:		WORK ORDER CHANGES					
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